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## Novolac Epoxy Crack Filler

Highly Chemically Resistant Gel

Epoxy Novolac Gel for Shallow Repairs on Vertical and Horizontal Surfaces

Epoxy.com Product #655

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### Epoxy Novolac Crack Filler Description

**Epoxy Novolac Chemical Resistant Crack Filler Product #655** is a two component 100% solids Epoxy Novolac crack filler (gel) designed for shallow repairs on either vertical or horizontal surfaces. Because **Epoxy Novolac Chemical Resistant Crack Filler Product #655** is a 100% solids formulation, it can be applied thicker on horizontal surfaces when required.

### RECOMMENDED FOR

**Epoxy Novolac Chemical Resistant Crack Filler Product #655** is recommended for repairing cracks and defects in concrete or masonry where a high chemical exposure is possible.

### PRIMER

None necessary

### TOPCOAT

Optional. This product can be over-coated with many suitable epoxy and urethane products.

### LIMITATIONS

- Color stability may be affected by environmental conditions such as high humidity, chemical exposure or exposure to certain types of lighting such as sodium vapor lights or UV light sources.
- Colors may vary from batch to batch.
- This product is not UV color stable.
- Substrate temperature must be 5°F above dew point.
- All new concrete must be cured for at least 30 days prior to application.
- Allow the Novolac Epoxy Crack Filler to become tack free prior to topcoating. See application instructions.
- Physical properties are typical values and not specifications.

## MIXING AND APPLICATION INSTRUCTIONS

### Epoxy Novolac Chemical Resistant Crack Filler Product #655

#### PRODUCT STORAGE

Store **Epoxy Novolac Chemical Resistant Crack Filler Product #655** at normal room temperature before using. Continuous storage should be between 60 and 90°F. Low temperatures or temperature fluctuations may cause crystallization.

#### SURFACE PREPARATION

All dirt, foreign contaminants, oil and laitance must be removed to assure a trouble free bond to the substrate. A test should be made to determine that the concrete is dry; this can be done by placing a 4' x 4' plastic sheet on the substrate and taping down the edges. If after 24 hours, the substrate is still dry below the plastic sheet, then the substrate is dry enough to start repair work. This product is intended for hairline cracks and other fractures up to an 1/8 inch in width. Remove all unsound concrete from within the crack to be repaired and thoroughly vacuum all debris and dust from within the crack opening.

#### PRODUCT MIXING

This product has a mix ratio of 2 part A to 1 part B by volume. To mix, simply measure out two parts by volume for part A with one part by volume for part B. Mix the two components together thoroughly with slow speed mixing equipment such as a jiffy mixer, putty knife or spatula until the material is thoroughly mixed and uniform in color. Mix only an amount of material that can be used in the allotted pot life period. Insufficient mixing or improper mixing may result in product failure.

#### PRIMING

No priming is necessary.

#### PRODUCT APPLICATION

The mixed material can be applied by marginal trowel, putty knife or any other suitable equipment. Make sure that all unsound concrete is removed prior to repairing the area.

#### RECOAT OR TOPCOATING

Allow the **Epoxy Novolac Chemical Resistant Crack Filler Product #655** to cure (tack free) prior to coating over the applied material. If excessive amounts are spread well beyond the crack repair or in areas where surface repairs have been implemented, it is best to check the cured areas for any possible amine blush (a whitish, greasy film or deglossing) prior to coating over this material. If a blush is present, it can be removed by any standard type detergent cleaner prior to topcoating or recoating. Many epoxy coatings and urethanes are compatible for use over this product as well as multiple coats of this product.

#### CLEANUP

Use Xylene.

#### FLOOR CLEANING

Caution! Some cleaners may affect the color of the fast set gel installed. Test each cleaner in a small area, utilizing your cleaning technique. If no ill effects are noted, you can continue to clean with the product and process tested.

#### RESTRICTIONS

Restrict the use of the area to light traffic and non-harsh chemicals until the coating is fully cured (see technical data under full cure). It is best to let the floor remain dry for the full cure cycle.

## Properties

SOLIDS BY WEIGHT:	100%
SOLIDS BY VOLUME:	100%
VOLATILE ORGANIC CONTENT:	Zero pounds per gallon
COLOR:	Gray (when mixed)
RECOMMENDED THICKNESS:	1/8" cracks or thin build repairs
COVERAGE PER GALLON:	0.20 cubic feet or 1,842 lineal feet @ 1/8" x 1/8" for the 1 1/2 gallon kit.
MIX RATIO:	2 part A to 1 part B by volume 12.65 to 5.8 by Weight
PACKAGING	1.5 gallon and 3 gallon Units
SHELF LIFE:	1 year in unopened containers
HEAT DEFLECTION TEMP.:	52 degrees C (125.6 degrees F)
FLEXURAL STRENGTH:	8,200 psi @ ASTM D790
COMPRESSIVE STRENGTH:	10,100 psi @ ASTM D695
TENSILE STRENGTH:	6,150 psi @ ASTM D638
ULTIMATE ELONGATION:	2.3%
GARDNER VARIABLE IMPACTOR:	50 inch pounds direct – passed
ABRASION RESISTANCE:	Taber abraser CS-17 calibrase wheel with 1000 gram total load and 500 cycles= 34 mg loss
ADHESION:	430 psi @ elcometer (concrete failure, no delamination)
HARDNESS:	Shore D= 70
VISCOSITY Mixed:	1,372,800 cps (typical)
DOT CLASSIFICATIONS:	Part A "not regulated" Part B "CORROSIVE LIQUID N.O.S, 8, UN1760, PGIII"

## CURE SCHEDULE:

(70°) Pot life (1 1/2 gallon volume)	1-2 hours
Tack free (dry to touch)	8-12 hours
Recoat or topcoat	8-12 hours
Light foot traffic	12-18 hours
Full cure (heavy traffic)	2-7 days
Application Temperature:	60-90 degrees F

## CHEMICAL RESISTANCE of

### Epoxy Novolac Chemical Resistant Crack Filler Product #655:

CHEMICAL RESISTANCE	REAGENT RATING
butanol	D

xylene	D
1,1,1trichloroethane	C
MEK	A
ethyl alcohol	C
skydrol	C
10% sodium hydroxide	D
50% sodium hydroxide	D
10% sulfuric acid	D
70% sulfuric acid	B
10% HCl (aq)	D
5% acetic acid	D

Rating key: A - not recommended, B - 2 hour term splash spill, C - 8 hour term splash spill, D - 72 hour immersion, E - long term immersion. NOTE: extensive chemical resistance information is available through your sales representative.

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Proper mixing and installation is critical to the optimal success of all product. See [Installation Tips](#), [Techdata](#), & [MSDS](#) for more details on our products. Be sure to contact us with any questions and/or concerns that you have.

For more information please contact:

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